

**Claims:**

---

1. **A method** for shaping a sheet metal lid preferably for a beverage can, comprising a panel (10) and an openable area defined in said panel by a score line (16) and a mounting place (11) for a tab for breaking in said openable area (17); wherein
  - (i) at least one projection (20,21a,21b) in said panel (10) is shaped twice,
    - (a) firstly **for shaping** a pre-form (20\*) of the projection out of said panel (10) of said sheet metal lid, said pre-form being located near an attaching portion (31) of a tab (30), but at a distance from said mounting place (11),
    - (b) secondly for **re-forming** at least a front edge (20'',21b') of said pre-form (20\*) of said at least one projection,
  - (ii) wherein no score line (16) is provided in said panel, neither during shaping, nor during re-forming;
  - (iii) for obtaining a better blocking of an outer edge portion (31c) of the attaching portion – said outer edge portion being associated with said re-formed front edge.
2. The method according to claim 1, wherein a score line (16) is introduced or inserted into said panel (10) after shaping said pre-form (20\*) of said at least one projection (20), particularly in a subsequent station.
3. Method according to claim 1, wherein said re-forming comprises an embossing, by which a top side (20c) of said projection (20) is flattened and stiffened.
4. Method according to claim 3, wherein said stiffening is a reduction of the sheet metal thickness by at least 10 %.
5. Method according to one of claims 1 and 2, wherein said score line (16) is formed into said panel (10) after re-forming said pre-form (20\*) of said at least one projection (20), particularly in a subsequent station.
6. Method according to claim 1, wherein said score line (16) is brought into said panel (10) **after** pre-shaping said pre-form (20\*) of said at least one projection (20) in said same panel, particularly in a subsequent station, and **prior to** re-forming said pre-form (20\*) of said at least one projection (20) in said same panel, particularly in a preceding station.

7. Method according to claim 6, wherein said subsequent station and said preceding station are identical.

